

Work Order ID 146214

Thursday, May 12, 2016 11:37:59 AM

146214

Page 1

Item ID: D2574

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft, In

Start Date: 5/12/2016 Start Qty: 12.00

12

Required Date: 5/26/2016 Req'd Qty: 12.00

12

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 12 2016

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2574	F
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100

0.13

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

4.44

Memo

HAAS CNC vertical machine #1

Program Batch No. 146214Double check by: SS

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

0.00

110

110

CONVENTIONAL MILLING MACHINE

Mill Conv

0.36

Memo

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

PTO →

DQA:

Date: 16.06.21



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16-06-17

Work Order update only ☐

Work Order: 146214 Part No. D 2574 NCR No. 16-5846		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☒</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>						Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☒	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐																																																																																																
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Power failure during Profiling Part, Z axe drop .200" in to Part.				Scrap & destroy Replace B143 817																																																																																																																																			
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Thursday, May 12, 2016 11:37:59 AM

Page 2

Setup Start *NS1*

Stop *NS2*

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Insp. Stamp

B.A 16/05/31

12

6

16-05-20

Quality Control

0.24

Quality Control

12

c

DAS
14
9-89

9-89
16/06/02

0.36

Hand Finishing

12 x 9 all 16/60/6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 146214

Thursday, May 12, 2016 11:37:59 AM

146214

Page 3

Item ID: D2574

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, Aft, In

Stop ***NS2***

Start Date: 5/12/2016 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 5/26/2016 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
150	<i>M 134631</i>								
Powdercoat	Memo	0.24							
Powder Coating	START TIME: <i>8:45.</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>9:15.</i>								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.12							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.12							
Packaging									

12 0 16-06-15 2343

DAS
38
9-89

(12) JUN 15 2016

12 JUN 16 2016 DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 146214***146214***

Page 4

Thursday, May 12, 2016 11:37:59 AM

Item ID: D2574

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft, In

Start Date: 5/12/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/26/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	1.20							
Quality Control									

MCS JUN 16 2016
MCS JUN 16 2016

JUN 16 2016

Picklist Print

Thursday, May 12, 2016 11:38:05 AM

Page 1

Work Order ID: 146214

Parent Item: D2574

Parent Item Name: Saddle, Aft, In

146214

D2574

Start Date: 5/12/2016

Required Date: 5/26/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005 Saddle Billet		Manufactured	No			110	Each	34.0000	1	12			
D6101-005										**	12 + 1	DAS 20 9-89	16-05-27

Location

MAT040

Loc Qty

34

Loc Code

143817

34

12 + 1

DAS
39
9-89

16-05-29

DART AEROSPACE LTD	Work Order: 176214
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	8.000	7.999		
F	0.490	0.510	281	.499	.499	.500	.502		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510	3125	.500	.500	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578	439	.568	.568	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.135		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.239	.239	.238	.237		
W	0.115	0.135		.125	.125	.124	.124		
X	0.307	0.312		.308	.309	.311	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.361	.361	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635	406	.625	.625	.625	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.248	.247	.244		
AE	1.500	1.520		1.513	1.513	1.514	1.514		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.270	.270	.270		
AH	0.240	0.260		.245	.245	.246	.246		
AI	2.000	2.020		2.003	2.003	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Date

Measured by:	116-05-28
Date:	

Audited by:	9-89
Date:	16/06/02

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	146214
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	27	28		
A	0.438	0.443		438	438	438	438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510	281	0.500	0.500	0.500	0.500		
G	0.257	0.262		258	258	2.58	2.58		
H	0.375	0.380		375	375	375	375		
I	0.490	0.510	3125	5015	500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578	439	568	568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		130	130	0.135	0.135		
Q	0.115	0.135		125	125	0.124	0.125		
R	0.240	0.260		250	250	0.250	0.249		
S	0.115	0.135		126	126	0.126	0.125		
T	0.178	0.198		188	188	188	188		
U	3.210	3.250		3.229	3.229	3.230	3.230		
V	0.230	0.250		239	238	0.240	0.239		
W	0.115	0.135		0.122	0.122	0.121	0.122		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		760	760	760	760		
Z	0.352	0.372		0.362	0.363	0.362	0.362		
AA	0.470	0.530		500	1500	500	500		
AB	0.615	0.635	406	0.625	0.625	0.625	0.625		
AC	0.053	0.073		063	063	063	063		
AD	0.240	0.260		249	248	0.249	0.249		
AE	1.500	1.520		1.514	1.514	1.510	1.510		
AF	0.115	0.135		125	125	0.135	0.135		
AG	0.240	0.280		270	270	0.260	0.260		
AH	0.240	0.260		248	246	0.248	0.248		
AI	2.000	2.020		2.004	2.004	2.000	2.000		
AJ	0.023	0.043		033	033	033	033		

Accept/Reject

DAS

Measured by:	J 2016-05-30/8.08	Audited by:	14
Date:	16/05/19-85	Date:	9-00 16/06/02

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 146214
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

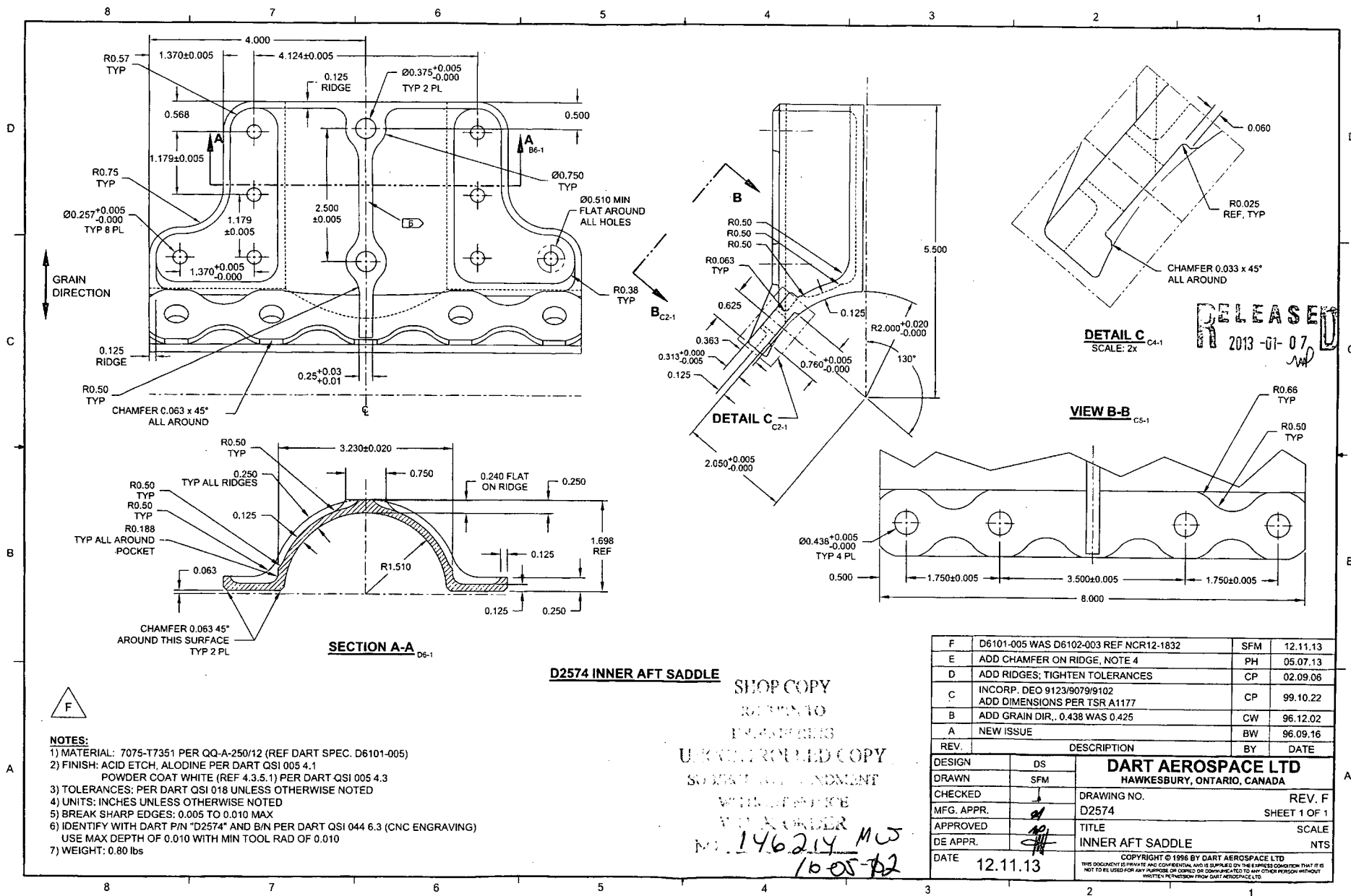
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	#11	#12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.124	0.125	0.125	0.125		
R	0.240	0.260		0.250	0.249	0.250	0.250		
S	0.115	0.135		0.126	0.125	0.126	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.240	0.239	0.239		
W	0.115	0.135		0.122	0.122	0.122	0.121		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.363	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.249	0.249	0.249		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.248	0.248	0.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject							DAS		

Measured by: B.F.	DAS
Date: 16/05/13	08

Audited by: 14	9.00
Date: 16/06/02	

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



NOTES:

- 1) MATERIAL: 7075-T7351 PER QQ-A-250/12 (REF DART SPEC. D6101-005)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2574" AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USE MAX DEPTH OF 0.010 WITH MIN TOOL RAD OF 0.010
- 7) WEIGHT: 0.80 lbs

D2574 INNER AFT SADDLE

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBMIT FOR ENDORSEMENT

WITH SPECIFIC

FOR ORDER

NO. 146214 MJS

10-05-02

F	D6101-005 WAS D6102-003 REF NCR12-1832	SFM	12.11.13
E	ADD CHAMFER ON RIDGE, NOTE 4	PH	05.07.13
D	ADD RIDGES; TIGHTEN TOLERANCES	CP	02.09.06
C	INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	CP	99.10.22
B	ADD GRAIN DIR., 0.438 WAS 0.425	CW	96.12.02
A	NEW ISSUE	BW	96.09.16
REV.	DESCRIPTION	BY	DATE

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	<i>PH</i>	D2574	SHEET 1 OF 1
APPROVED	<i>CP</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	INNER AFT SADDLE	NTS
DATE	12.11.13	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	